

Work Order ID 126948

December-02-14 11:14:29 AM

Exp Monday Dec 8
126948

Page 1

Item ID: D4666-041 Accept *N900040100* Setup Start *NS1*
 Revision ID: Stop *NS2*
 Item Name: Armrest Assembly
 Start Date: 12/02/14 Start Qty: 3.00 *3* Cust Item ID:
 Required Date: 12/05/14 Req'd Qty: 3.00 *3* Customer:
 Reference:

Approvals: Process Plan: *W* Date: Tooling: Date: Run Start *NR1*
 QC: Date: SPC (Y/N): Date: Stop *NR2*

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
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Draw Nbr	Revision Nbr
D4666	A

100	Large Fab	0.00							
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100 *3 EL 14-12-3*

Large Fab Memo 0.00

Large Fab

- 1- Cut tube at 38.00"
- 2- Bend tube as per dwg
- 3- Cut ends of tube to righth dimension as per dwg
- 4- Drill tube as per Dwg
- 6- Deburr

120	QC6- Inspect dimensions to drawing	0.00							
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120 *3 9B*

QC Memo 0.00

Quality Control *14-12-03*

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Item ID: D4666-041 Accept *N9000040100* Setup Start *NS1*
 Revision ID: Stop *NS2*
 Item Name: Armrest Assembly
 Start Date: 12/02/14 Start Qty: 3.00 *3* Cust Item ID:
 Required Date: 12/05/14 Req'd Qty: 3.00 *3* Customer:
 Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____ Run Start *NR1*
 QC: _____ Date: _____ SPC (Y/N): _____ Date: _____ Stop *NR2*

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
124	Weld per dwg A/R 4130 rod Batch: <u>M127925</u>	0.00				<u>3</u>	<u>2</u>	<u>1411-3</u>	
124									
Large Fab	Memo	0.00							
Large Fab	WELD CAPS AND GRIND FLUSH AS PER DWG								

126	QC10- Inspect visual per QSI004- ground welds	0.00							
126									
QC	Memo	0.00							
Quality Control									

DAS
38
9-89

DEC 03 2014

128	QC5- Inspect part completeness to step on W/O	0.00							
128									
QC	Memo	0.00							
Quality Control									

DAS
38
9-89

DEC 03 2014

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DEC 05 2011

61

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Item ID: D4666-041

Accept

N900040100Setup Start ***NS1***

Revision ID:

Item Name: Armrest Assembly

Stop ***NS2***

Start Date: 12/02/14 Start Qty: 3.00

3

Cust Item ID:

Required Date: 12/05/14 Req'd Qty: 3.00

3

Customer:

Reference:

Approvals:

Process Plan: _____

Date: _____

Tooling: _____

Date: _____

Run Start ***NR1***

QC: _____

Date: _____

SPC (Y/N): _____

Date: _____

Stop ***NR2***Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run Hours

Tool ID

Tool #

Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

160

QC21- Final Inspection - Work Order Release

0.00

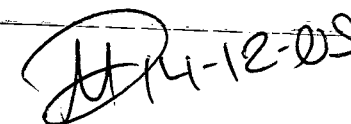
160

QC

Memo

0.00

Quality Control





Picklist Print

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Page 1

Work Order ID: 126948

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Parent Item: D4666-041

D4666-041

Parent Item Name: Armrest Assembly

Start Date: 12/02/14

Required Date: 12/05/14

Start Qty: 3.00

Required Qty: 3.00

Comments: IPP REV:A 12.06.11 NEW ISSUE DD VERF:EC

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
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D3017-11		Manufactured	No			124	Each	67.0000	2	6			
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D3017-11

Cap

B 14-12-2

Location

Loc Qty

Loc Code

WA001

67

116790

67

6

M4130NT0.750W.049

Purchased

No

100

f

187.7900

3.17

11

M4130NT0 750W 049

B 14-12-2

4130 RD Tube .750 x .049W

Location

Loc Qty

Loc Code

MAT028

5

m127866

5

MAT033

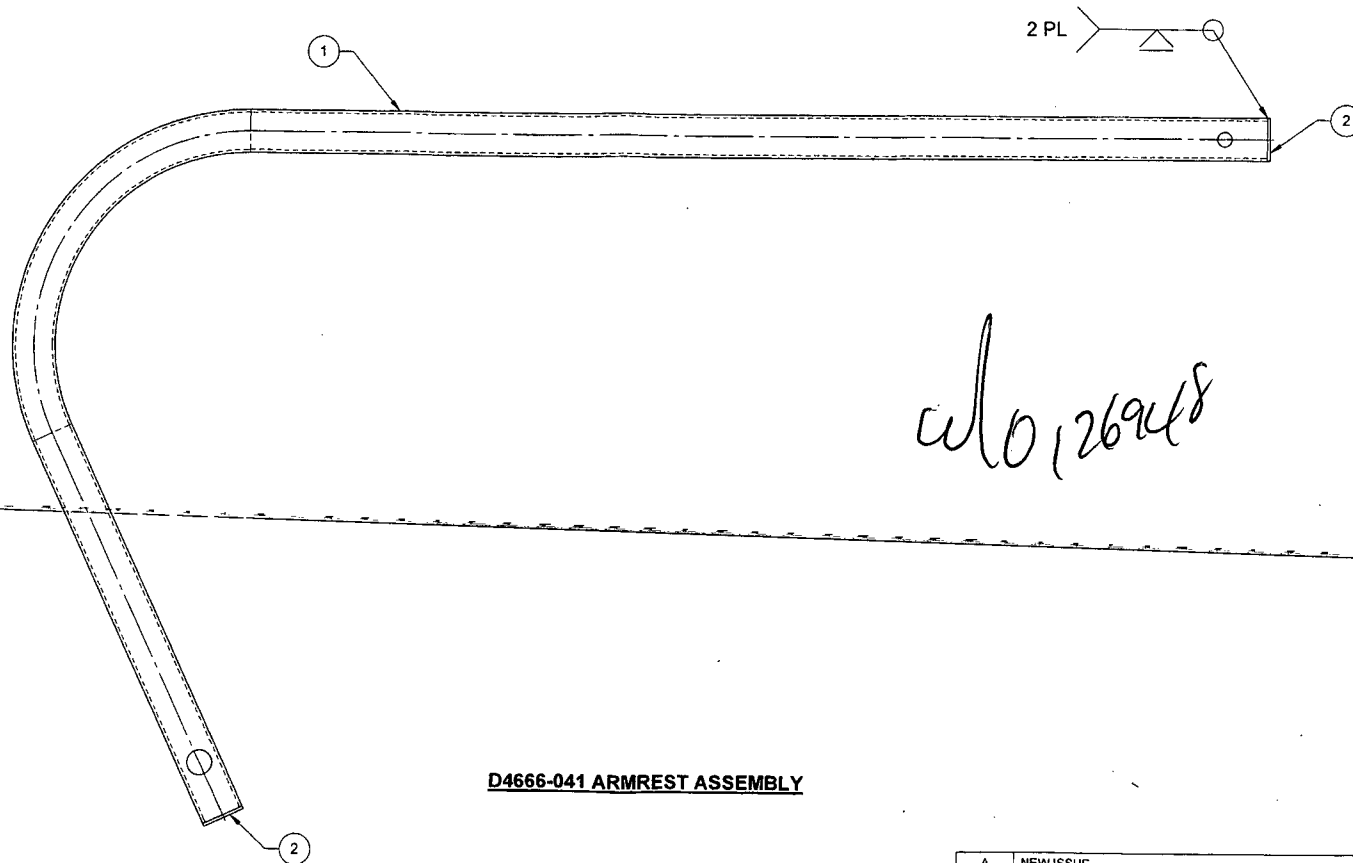
182.79

1130619

182.79

9.5

ITEM	QTY	P/N	DESCRIPTION
	X	D4666-041	ARMREST ASSEMBLY
1	1	D4666-1	ARMREST
2	2	D3017-11	END CAP



10126948

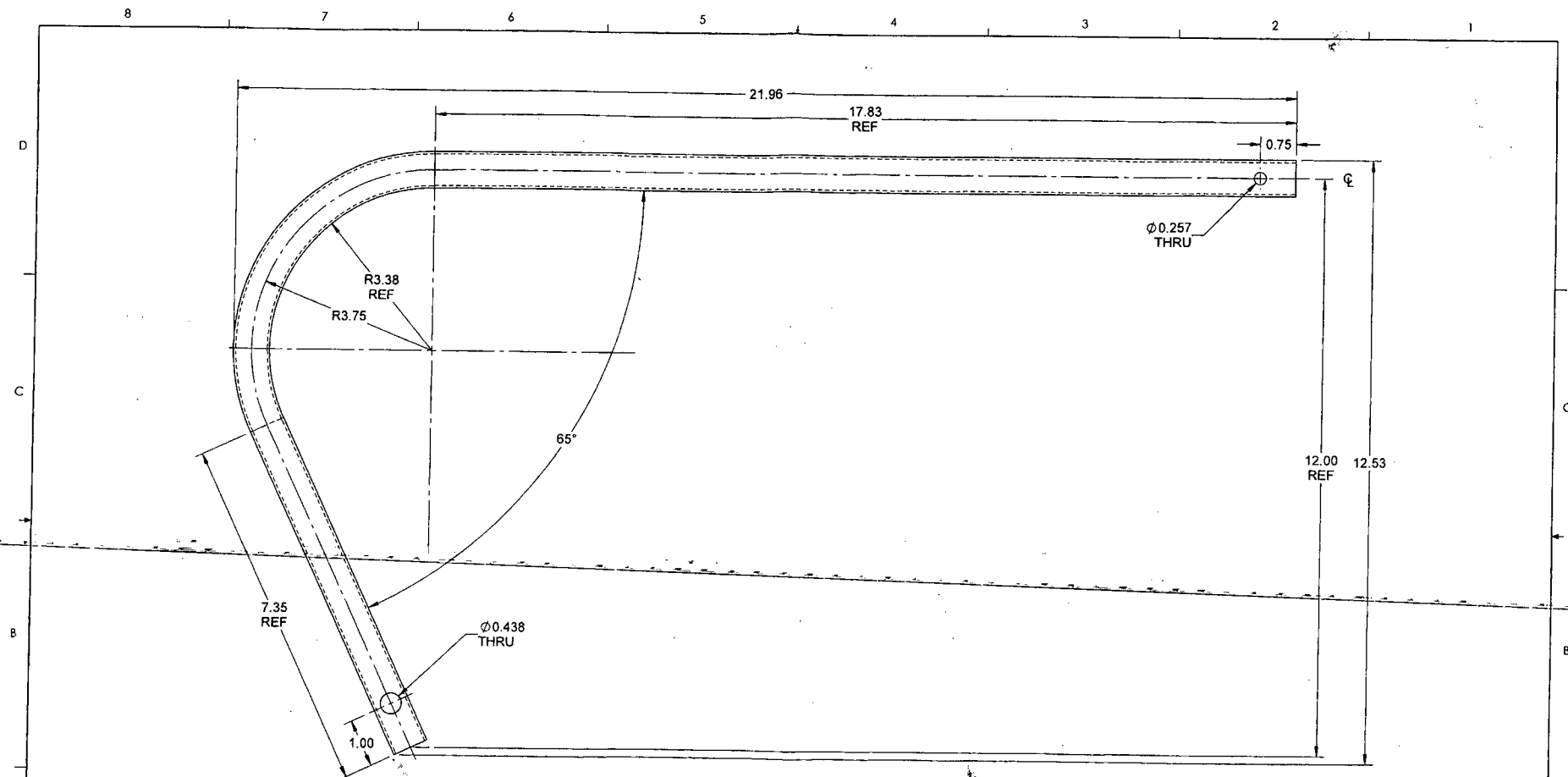
D4666-041 ARMREST ASSEMBLY

NOTES:

- 1) MATERIAL: N/A
- 2) FINISH: POWDER COAT GREY SANDEXT (4.3.5.6) PER DART QSI 005 4.3
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: N/A
- 6) IDENTIFICATION: IDENTIFY WITH DART P/N "D4666-041" AND B/N "BXXXXX" PER DART QSI 044 6.1 (FINE POINT MARKER)
- 7) WEIGHT: 1.01 lbs

RELEASED
2012-07-09
P PER DEN 12-04

A	NEW ISSUE	AJS	12.06.08
REV.	DESCRIPTION	BY	DATE
DESIGN	AJS	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWN	AJS	DRAWING NO.	REV. A
CHECKED	SP	D4666	SHEET 1 OF 2
MFG. APPR.	N	TITLE	SCALE
APPROVED	12/06/08	ARMREST ASSEMBLY	NTS
DE APPR.	#	COPYRIGHT © 2012 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.	
DATE	12.06.08		



D4666-1 ARMREST

NOTES:

- 1) MATERIAL: AISI 4130N SEAMLESS STEEL TUBING, $\phi 0.750 \times 0.049$ WALL
PER MIL-T-6736 OR AMS 6371/6360/6361/6362/6373/6374
REF M4130NT0.750W.049
- 2) FINISH: N/A
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: N/A
- 7) WEIGHT: 0.99 lbs
- 8) FLAT LENGTH 32.75 ESTIMATED

RELEASED
2012-07-09

DESIGN	AJS	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWN	AJS		
CHECKED	<i>[Signature]</i>	DRAWING NO. D4666	REV. A
MFG. APPR.	<i>[Signature]</i>	SHEET 2 OF 2	
APPROVED	<i>[Signature]</i>	TITLE ARMREST ASSEMBLY	SCALE
DE APPR.	<i>[Signature]</i>	NTS	
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